

\*Date: Tuesday, 09/10/2007 2:55:16 PM  
 User: Linda Lacelle

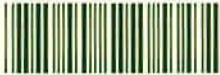
## Process Sheet

Split 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35031 -1		
Estimate Number	: 12883	Part Number	: D3560043
P.O. Number	: N/A	Drawing Number	: D3560 REV C
This Issue	: 09/10/2007 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: N/A Type : SMALL /MED FAB	Material	: N/A
Previous Run	: 35031	Due Date	: 19/10/2007
Written By	:	Qty:	5 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC Est Rev B ECN 987 07.10.09 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
-----	--------------------	-------------------------



Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)  
 6061-T6 Bar 0.50" x 5.00"  
 Batch: 3104598

BG 07.10.28 (10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blanks 15.500" long

BG 07.10.28 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

BG 07.10.29 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07.10.29 (10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 07/10/29





Date: Tuesday, 09/10/2007 2:55:16 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35031

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

PLATE

334478

07-11-29

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad )
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch ( 60° )
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

07-11-29 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07-11-30 (x5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-11-30 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-12-03 (5)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-03 (x5)

1880

1880

1880



Date: Tuesday, 09/10/2007 2:55:16 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35031

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

batch: B35330 x (5)

MF 07-12-03

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

MF 07-12-03 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/03 (x5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WLA

07-12-10

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
07/12/11

Job Completion



07-12-11





Date: Friday, 10/5/2007 10:58:42 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35031		
Estimate Number	: 12883		
P.O. Number	:	Part Number	: D3560043
This Issue	: 10/5/2007 S.O. No. :	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: EC E
Previous Run	: 34966	Material	:
Written By	:	Due Date	: 10/19/2007 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC		

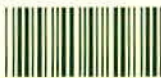
## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X05000	6061-T6 Bar 50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)  
 6061-T6 Bar 0.50" x 5.00"  
 Batch: \_\_\_\_\_

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks 15.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: \_\_\_\_\_ & Dwg D3560 Rev: \_\_\_\_\_

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35031

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
PLATE

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	35031
Description: Arm		Part Number:	D3560-3
Inspection Dwg: D3560	Rev: <i>PL</i>	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

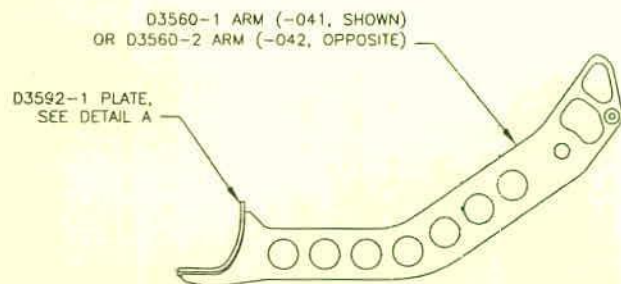
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Ø0.196	+0.005/-0.001	.196	✓			
Ø1.000	+0.010/-0.001	1.004	✓			
Ø0.900	+0.010/ 0.001	.900	✓			
0.500	+/-0.010	.499	✓			
0.250	+/-0.010	.251	✓			
0.275	+/-0.010	.275	✓			
0.188	+/-0.010	.191	✓			
2.000	+/-0.010	2.005	✓			
1.750	+/-0.010	1.755	✓			
1.702	+/-0.010	1.707	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380x100°	✓			
0.250 Deep	+/-0.010	.247	✓			

Measured by: <i>BC</i>	Audited by: <i>JML</i>	Prototype Approval:	N/A
Date: 07.10.28	Date: 07/10/28	Date:	N/A

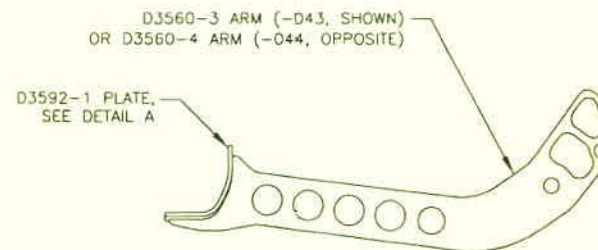
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue <i>P/O D3560-043</i>	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>JA</i>	<i>BE</i>



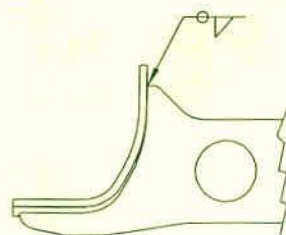
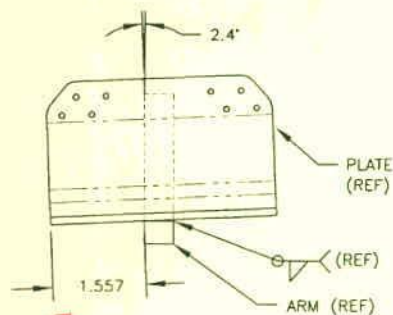




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	GP	DRAWN BY GP
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE
		1:4

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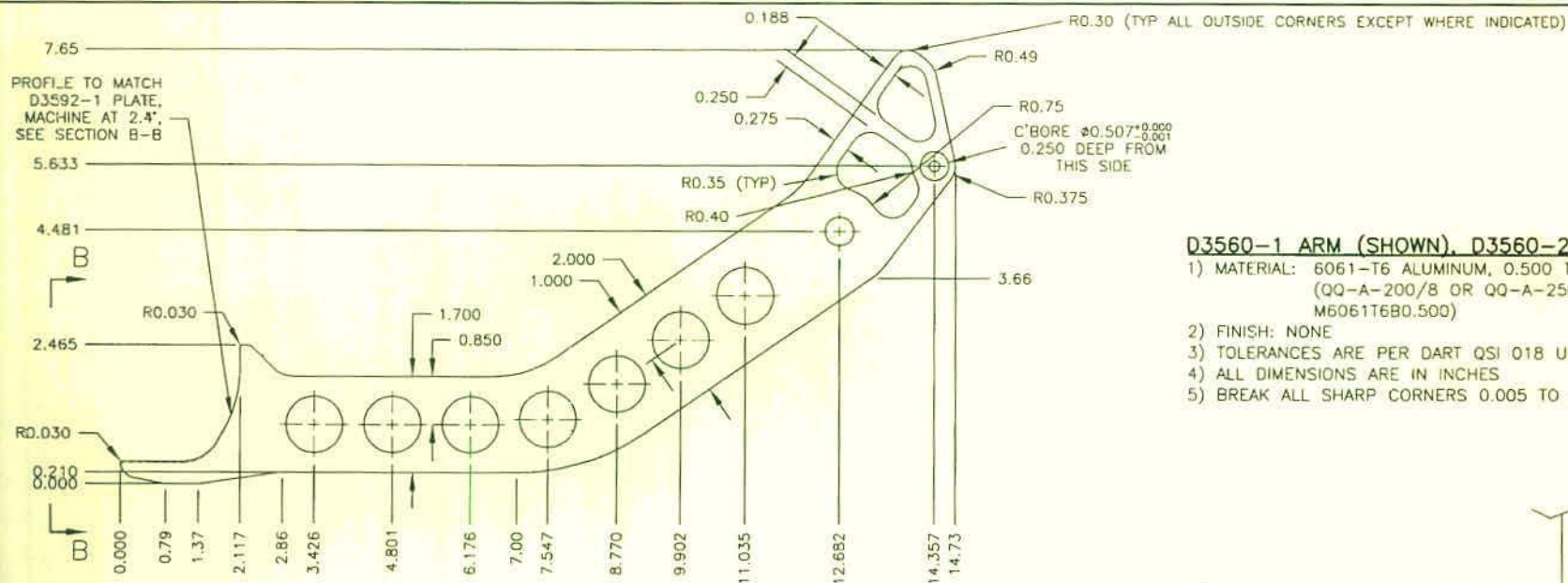
**DART** DART AEROSPACE LTD.  
HAMMILLSBURY, ONTARIO, CANADA

DRAWING NO. D3560 REV. C  
SHEET 1 OF 3

NO. 3503  
WORK ORDER  
SUBJECT TO AMENDMENT  
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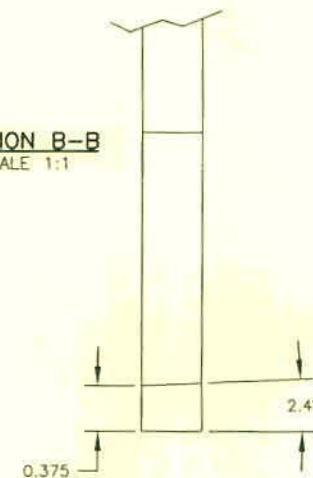




# **D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/B OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

## **SECTION B-B** SCALE 1:1



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07.06.19

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WORK ORDER  
NO 35031

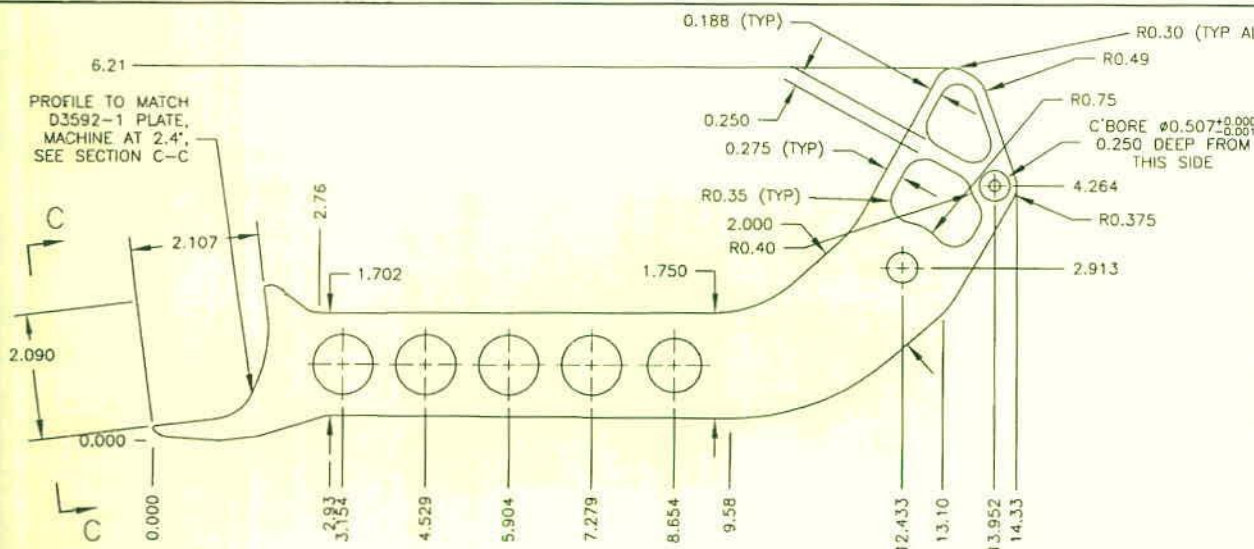
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CHECKED	90	APPROVED	90	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

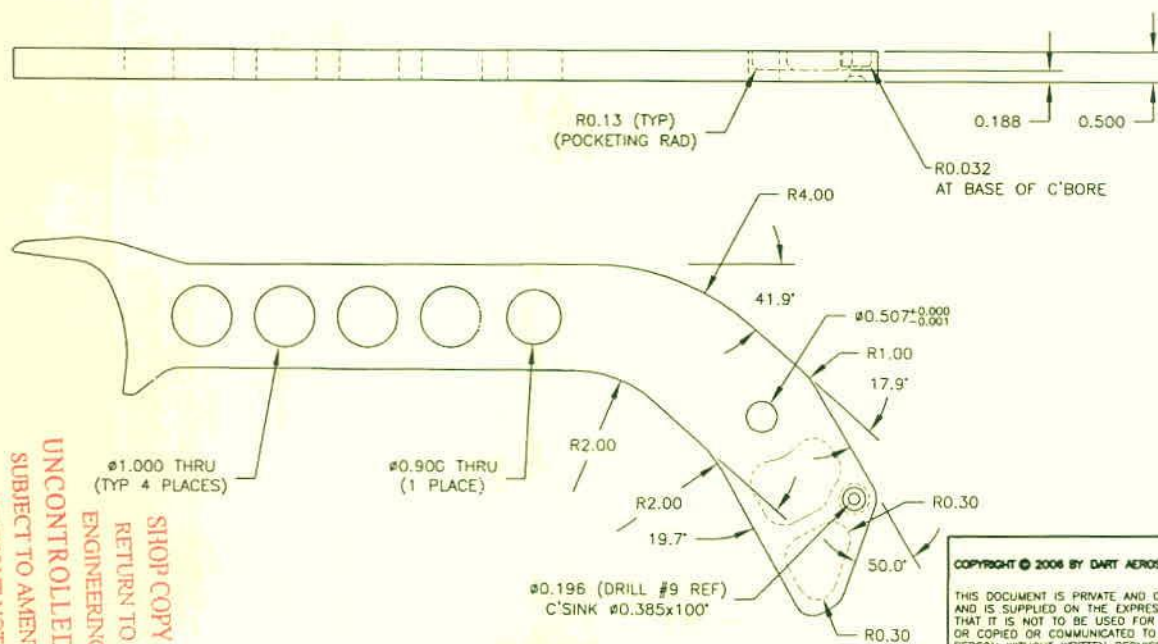




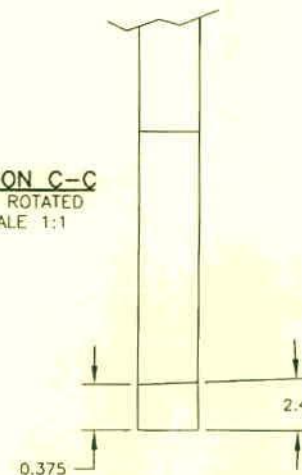


### D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



### SECTION C-C VIEW ROTATED SCALE 1:1



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07.06.19

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DESIGN	q	DRAWN BY	q	<b>DART</b>	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

